

Work Order ID 152683

Friday, November 04, 2016 10:13:47 AM

152683

Page 1

Item ID: D4365-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar Weldment

Start Date: 11/4/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/18/2016 Req'd Qty: 2.00

2

Customer:

Reference:

DAS
21
9-89

NOV 04 2016

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4365

B

100

0.00

100

Cold Saw

Memo

0.00

Hyd Mech

Cut D4365-1 blanks at 45.00"

extra material will be trim off at assembly

2

16-11-08
/SL

110

Weld per dwg & QSI004 4.5

0.00

110

autoweld 1

Memo

0.00

Automated Welding 1

1- USE GRINDER TO CHAMFER END AS PER DWG . SEE "DETAIL A"

SEE NOTE 8 FOR SURFACE BUILDUP

FOR AUTOMATED WELDING USE 8259 HARDCOAT

BATCH: 131775

2

16-11-08
/SL

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

①

16-11-15

DAS
9
9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.01

Quality Control

②

16-11-15

DAS
9
9-89

140

Identify as per dwg & Stock Location:

0.00

140

Packaging

Memo

0.00

Packaging

LOCATION: WA001

2

16-11-15
JBL

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.03

DAS
21
9-30

NOV 15 2016

Quality Control

DAS
21
9-30

NOV 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Friday, November 04, 2016 10:13:51 AM

Page 1

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152683

Parent Item: D4365-041

D4365-041

Parent Item Name: Bar Weldment

Start Date: 11/4/2016

Required Date: 11/18/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 15.10.16 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No				f	157.4710		7.894737			

M304B0 250x0 500

304 BAR .250 x .500

**

16-11-07
JLC

Location

Loc Qty

Loc Code

WA002

157.471

134172

6

m133596

38.948

m133923

1.85

m135822

110.673

~~7.5~~ 7.5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

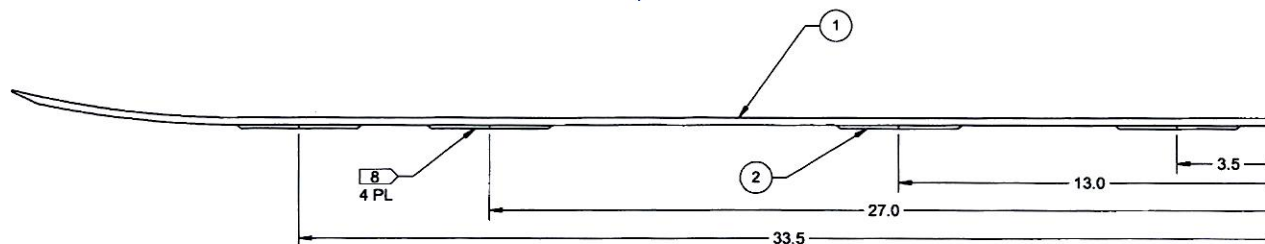
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OTHER : _____																																																															

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4365-041	BAR WELDMENT
1	1	D4365-1	BAR
2	A/R	8259/2059B	HARD SURFACING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152683 MJS
16-11-04



B-B D4365-041 BAR WELDMENT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N *D4365-041 PER QSI 044 6.1
- 7) WEIGHT: D4365-041 = 1.92 lbs
- 8) BUILDUP HARD SURFACING 0.18 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR, BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

B	ADD D4365-041/043 WELDMENTS, MODIFY D4365-1 (ADD FORMING DETAILS, REMOVE 0.188 HOLES), MODIFY D4365-3 (REMOVE 0.188 HOLES), ADD D4365-1F, ADD AUTOMATED WELDING NOTE	DB	16.05.24
A	NEW ISSUE	SC	11.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	DB		
CHECKED	WM		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	DS	WEARBAR	
DATE	16.05.24	REV. B SHEET 1 OF 3 SCALE NTS	

RELEASED
2016-06-16
EW 4-594
APPROVED

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